

**DEPARTMENT OF TRANSPORTATION**

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



Bay Area Branch

690 Walnut Ave.St. 150

Vallejo, CA 94592-1133

(707) 649-5453

(707) 649-5493

Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: 69.28**WELDING INSPECTION REPORT****Resident Engineer:**Pursell, Gary**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-001837**Date Inspected:** 19-Mar-2008**Project Name:** SAS Superstructure**OSM Arrival Time:** 600**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 1730**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Shanghai China**CWI Name:** Chen Xi, Sun Wei**CWI Present:** Yes No**Inspected CWI report:** Yes No N/A**Rod Oven in Use:** Yes No N/A**Electrode to specification:** Yes No N/A**Weld Procedures Followed:** Yes No N/A**Qualified Welders:** Yes No N/A**Verified Joint Fit-up:** Yes No N/A**Approved Drawings:** Yes No N/A**Approved WPS:** Yes No N/A**Delayed / Cancelled:** Yes No N/A**Bridge No:** 34-0006**Component:** OBG**Summary of Items Observed:**

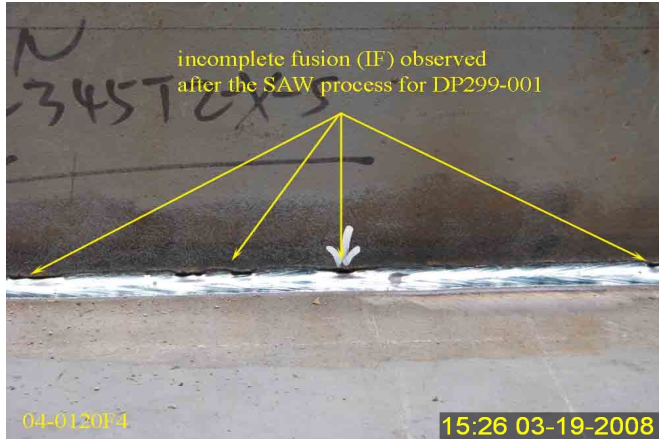
This Quality Assurance (QA) inspector arrived at ZPMC for observation of the SAS super structure fabrication. This QA inspector observed ZPMC weld a Production Monitoring Test (PMT) for deck plate DP008-001 and DP299-001 at gantry-1. This is ZPMC's attempt to weld the PMT completely before starting welding of production panels as required by the special provisions. The test run was successful and ZPMC started production welding at approximately 1000 hrs. Upon completion of the Submerged Arc Welding (SAW) process for PMT-1 it was determined by ZPMC QC/CWI Chen Xi that the PMT met the acceptance criteria for visual and ultrasonic testing. The macros were then laid out by this QA inspector to be cut by ZPMC and reviewed by all parties involved. ZPMC then proceeded with the welding of production deck panel number DP008-001 and DP299-001 using the Gas Metal Arc Welding (GMAW) and Submerged Arc Welding (SAW) processes. This QA inspector observed ZPMC welding personnel using gantry # 1 for the welding process and observed that the amperages, voltage and travel speed of each of the 6 welding heads used for production and PMT welding were within the requirements of WPS-B-T-2342-U1 (U Rib)-3. The Ambient temperature in the shop was recorded at 12°C with the steel temperature at 13°C. Deck panel DP008-001 was welded in two groups group A included Rib numbers U82 and U78. Group B was rib number U91. Deck panel DP299-001 was also welded in two groups; group A included Rib numbers U34 and U33. Group B was rib number U55. It was noted that ZPMC had 2-CWI and 3- QC inspectors in bay 1 this date and ABF had 4 QC representatives present this day for bay 1. By the end of this QA inspectors shift ZPMC had not completed the SAW welding for DP008-001 or DP299-001 which was continuing into the next shift for completion of the welding process. 1 rib on both production panels that included 2 weld each were remaining.

---

# WELDING INSPECTION REPORT

( Continued Page 2 of 2 )

---



## Summary of Conversations:

As noted in content above.

## Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact Pat Lowry, (858)344-2712, who represents the Office of Structural Materials for your project.

---

<b>Inspected By:</b>	Riley, Ken	Quality Assurance Inspector
<b>Reviewed By:</b>	Hager, Craig	QA Reviewer

---